

Shp July 6

Work Order ID 85743

85743

June-14-12 1:57:06 PM

Page 1

Item ID: D350-607-511

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Quick Release Basket Mounting Installation

Start Date: 14/06/2012 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/14 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D350-607-3	A
------------	---

100	
-----	--

100	DOCUMENT CONTROL
-------	------------------

DC	Memo
----	------

Document Control	Photocopy bluefile & type labels per PPPD350-607-511 CHG002
------------------	---

140	Pick Kit
-----	----------

140	Memo
-------	------

Packaging	
-----------	--

Packaging	
-----------	--

150	QC4- 100% Inspect kits for completeness
-----	---

150	Memo
-------	------

QC	
----	--

Quality Control	
-----------------	--

MLJ 12/06/14

S. 12/06/14

MLJ 12/06/14

12/06/14

S. 12/06/14

47

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Engineering <input type="checkbox"/>	
NCR No. _____	Work Order Update <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>	
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

FAULT CATEGORY

Landing Gear	Hardware	General
Bending Passes Below Min	Breaking <input type="checkbox"/>	Burrs <input type="checkbox"/>
Centre Not Concentric to O/S	Missing <input type="checkbox"/>	Contamination <input type="checkbox"/>
Cracks <input type="checkbox"/>	Size/Length <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>
Crushed/Crimp at Bending	Spinning <input type="checkbox"/>	Documentation/Data <input type="checkbox"/>
Inspection Strip in Tube	Threading <input type="checkbox"/>	Finish <input type="checkbox"/>
Other <input type="checkbox"/>	Wrong <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>
Positioned Wrong <input type="checkbox"/>	Drill Holes	Inspection Unqualified <input type="checkbox"/>
Ripples on Inner Bend <input type="checkbox"/>	Misaligned <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>
Torque Waves in Extrusion <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Jigs/Fixtures/Tooling <input type="checkbox"/>
Turning Sequence <input type="checkbox"/>	Over/Undersized <input type="checkbox"/>	Kit Incorrect <input type="checkbox"/>
Wave/Twist in Tube <input type="checkbox"/>	Too Many <input type="checkbox"/>	Kit Missing <input type="checkbox"/>
		Maintenance <input type="checkbox"/>
		Mislabeled <input type="checkbox"/>
		Off-Set <input type="checkbox"/>
		Orientation Misread <input type="checkbox"/>
		Out of Calibration <input type="checkbox"/>
		Out of Sequence <input type="checkbox"/>
		Outside Dimensions <input type="checkbox"/>
		Over/Under tolerance <input type="checkbox"/>
		Part Lost <input type="checkbox"/>
		Part Moved <input type="checkbox"/>
		Raw Material <input type="checkbox"/>
		Set-up <input type="checkbox"/>
		Supplier <input type="checkbox"/>
		Temperature/Cure <input type="checkbox"/>
		Weld <input type="checkbox"/>
		Wrong Stock Pulled <input type="checkbox"/>
		Other <input type="checkbox"/>

Picklist Print

June-14-12 1:57:10 PM

Page 1

Work Order ID: 85743

85743

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket Mounting Installation

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-28 JLM VERIFIED BY: LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3910-3		Manufactured	No			140	Each	20.0000	4	8	4	4	4
D3910-3 S+2 Crosstube Lug									**				
							<u>Location</u>	<u>Loc Qty</u>					
							st507	20					
							81574	20					
D3984		Manufactured	No			140	f	237.4840	2	4	4	4	4
D3984 Rubber Extrusion, Crosstube									**				
S+2							<u>Location</u>	<u>Loc Qty</u>					
							ST080	237.484					
							53707	237.484					
CUT (8) AT 3.00" LONG													
D4148-041		Manufactured	No			140	Each	1.0000	1	2	2	2	2
D4148-041 S+2 Crosstube Lug Assembly, Fwd									**				
							<u>Location</u>	<u>Loc Qty</u>					
							ST468	1					
							84191	1					
D4149-041		Manufactured	No			140	Each	1.0000	1	2	2	2	2
D4149-041 S+2 Crosstube Lug Assembly, Aft									**				
							<u>Location</u>	<u>Loc Qty</u>					
							ST468	1					
							82966	1					

Picklist Print

June-14-12 1:57:10 PM

Page 2

Work Order ID: 85743

85743

Parent Item: D350-607-511

D350-607-511

Parent Item Name: Quick Release Basket Mounting Installation

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 2.00

Required Qty: 2.00

AN4-14A

Purchased

No

140

Each

244.0000

16

32

**



AN4-14A

Spr
Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

357	100	
121349	100	
ST357	144	
120187	13	
120769	1	
121068	17	
121444	100	32
121708	13	

MS21042L4

Purchased

No

140

Each

3,157.000

16

32

**



MS21042L4

Sprut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300	3157	
119075	116	
121011	232	
121444	2509	32
121652	300	

NAS1149F0432P

Purchased

No

140

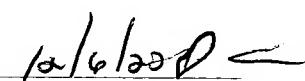
Each

636.0000

32

64

**

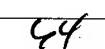


NAS1149F0432P

Spr
Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST275	636	
121350	636	64



NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS											
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Machining	Thermoforming	Large Fab	Crosstube	Small Fab	Finishing	Composite	Prod. Eng. Coor.	Rec/Store/Packaging	Supplier	Engineering Quality
NCR No. _____	Work Order Update														

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Offset/Setup									
Other									
Process									
Supplier									
Training									
Unauthorized									

FAULT CATEGORY

Landing Gear	Hardware			General		
	Bending Passes Below Min	Breaking	Burrs	Maintenance	Set-up	
	Centre Not Concentric to O/S	Missing	Contamination	Mislabeled	Supplier	
	Cracks	Size/Length	Cut Too Short	Off-Set	Temperature/Cure	
	Crushed/Crimp at Bending	Spinning	Documentation/Data	Orientation Misread	Weld	
	Inspection Strip in Tube	Threading	Finish	Out of Calibration	Wrong Stock Pulled	
	Other	Wrong	Inspection Incomplete	Out of Sequence		
	Positioned Wrong		Inspection Unqualified	Outside Dimensions		
	Ripples on Inner Bend	Drill Holes	Instructions Incomplete/Unclear	Over/Under tolerance		
	Torque Waves in Extrusion	Misaligned	Jigs/Fixtures/Tooling	Part Lost		
	Turning Sequence	Ovalized	Kit Incorrect	Part Moved		
	Wave/Twist in Tube	Over/Undersized	Kit Missing	Raw Material		
		Too Many				